

Date: Wednesday, 21/01/2009 7:38:17 AM
 User: Melanie Fauteux











Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: D-PAD BASE
Job Number	: 44992		
Estimate Number	: 13388		
P.O. Number	:	Part Number	: PB6743001193
This Issue	: 21/01/2009 S.O. No. :	Drawing Number	: B67-43001 P.25
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 11 Type : SMALL /MED FAB	Drawing Revision	: B1
Previous Run	: 41569	Material	:
Written By	:	Due Date	: 27/01/2009 Qty: 32 Um: Each
Checked & Approved By	: <u>mf 09-01-21</u>		
Comment	: est rev A new issue 08.06.19 EC verified: DD		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6S125	6061-T6 .125 Sheet
		
	Comment: Qty.: 0.0116 sf(s)/Unit Total : 0.3696 sf(s) 6061-T6 .125Sheet batch:- <u>110405</u> <u>B9-2-2</u>	
2.0	WATER JET	FLOW WATER JET
		
	Comment: FLOW WATER JET 1-Cut as per Dwg Dwg Rev: <u>B1</u> <u>B9-2-2</u> Prog Rev: <u>B1</u> 2-Deburr if necessary <u>CP 09/02/03</u> (40)	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>B9-2-2</u>	
4.0	QC8	SECOND CHECK
		
	Comment: SECOND CHECK <u>509/02/03</u> (40) counts	
5.0	MS21075L3	Nutplate
		
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 64.0000 Each(s) Nutplate batch: <u>M109371</u> <u>CP 09/02/04</u>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

~~CCR2643933~~

MS 20426403-4

Cherry Rivet



04.01.04



Comment: Qty.: 4.0000 Each(s)/Unit Total: 128.0000 Each(s)

X

Cherry Rivet
batch"

17105978

09/02/04

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

c'sink as per dwg.

Install nutplate with rivet.

09/02/04 (40)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

02/02/04 counter (x40)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

437

09/02/04 (40)

10.0

QC21

FINAL INSPECTION W/O RELEASE



Comment: FINAL INSPECTION W/O RELEASE

09/02/05

Job Completion



MF 09-02-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

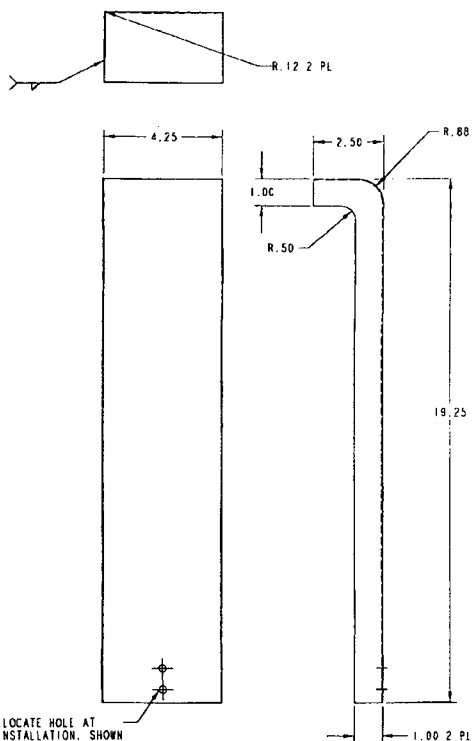
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

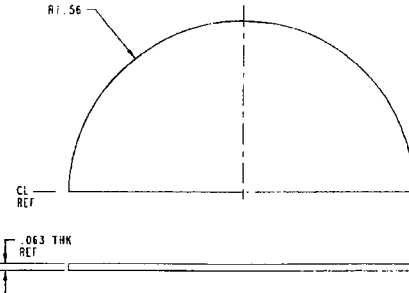
NOTE: Date & initial all entries

RELEASED

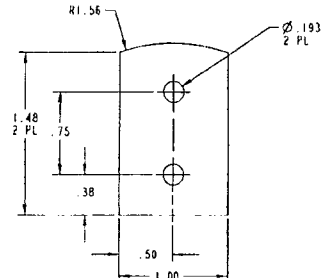
44992



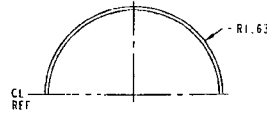
② -69 90 DEGREE COVER PLATE
MATERIAL: .032 THK, 6061-T6, QQ-A-250/11
SCALE 0.500



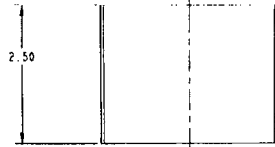
⑧ -339 D-PAD TOP
MATERIAL: .063 THK, 6061-T6, QQ-A-250/11
SCALE 2.000



⑧ -193 D-PAD BASE
MATERIAL: .125 THK, 6061-T6, QQ-A-250/11
SCALE 2.000



⑥ -185 D-PAD BACK PLATE
MATERIAL: .063 THK, 6061-T6, QQ-A-250/11
SCALE 1.000

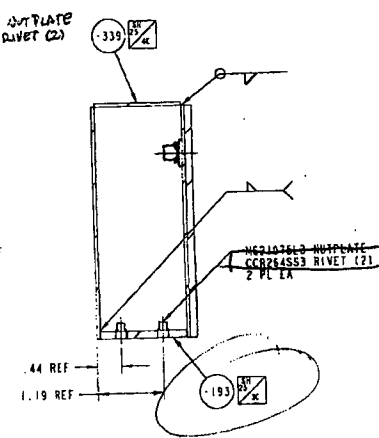
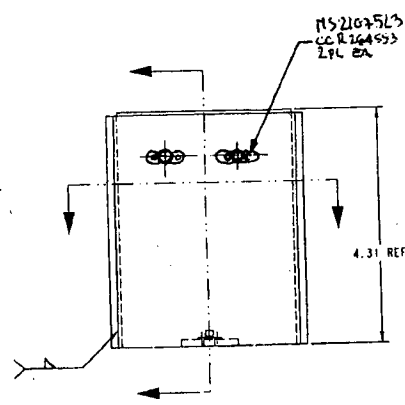
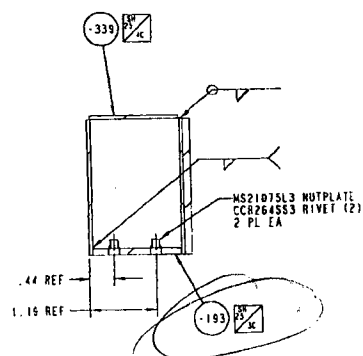
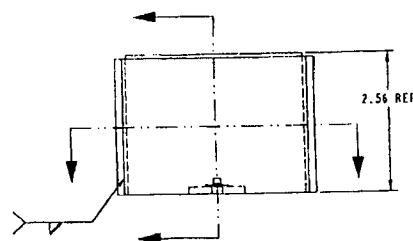
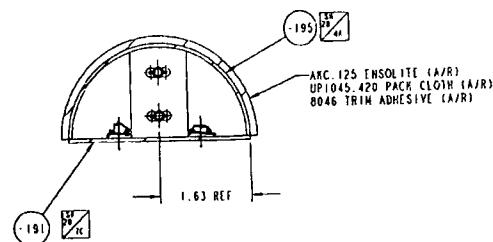
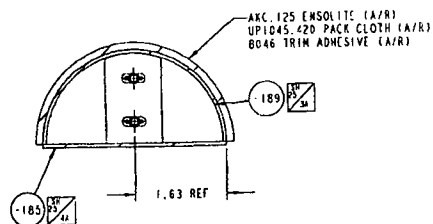


⑥ -189 D-PAD FACE
MATERIAL: .063 THK, 6061-T6, QQ-A-250/11
SCALE 1.000

PREMIER AVIATION, INC.
3800 Aviation Parkway, Grand Prairie, Texas 75050
DATE: 10/1/81
DESIGN: D105UV8
REV: 1
SCALE: 1/8" = 1"

ORIGINAL

RELEASED

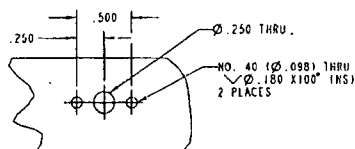


⑥ -83 SHORT D-PAD ASSEMBLY
SCALE 1.000

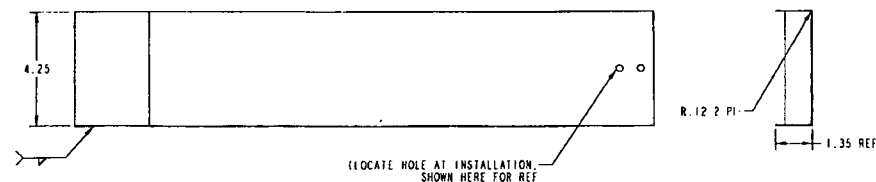
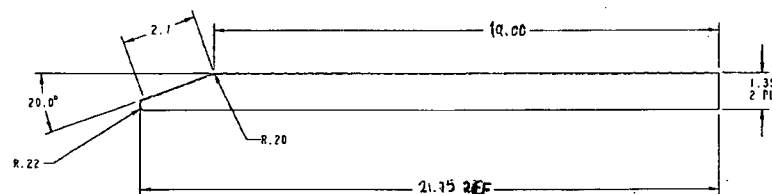
② -85 LONG D-PAD ASSEMBLY
SCALE 1.000

44992

RELEASED
46-41-20



DETAIL K
SCALE 2.000
3 PL 3 PL
REF REF



② -73 20 DEGREE COVER PLATE $\frac{P}{4}$ $\frac{P}{4}$
MATL: .032 THK. 6061-T6, QQ-A-250/11
SCALE 0.500

REFERENCE ONLY

44992

② -159 SUPPORT PLATE $\frac{P}{4}$ $\frac{P}{4}$
MATL: .030 THK. 6061-T6, QQ-A-250/11
SCALE 0.500

PART IS SYMMETRICAL ABOUT CENTER LINE

PREMIER AVIATION, INC.			
3000 Aviation Parkway, Grand Prairie, Texas 75052			
SIZE	CODE	INVENT NO.	REV.
D	OSUV8	B67-43001	Bf
SCALE:	BY:	DATE:	28 OF 45

ORIGINAL